

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023367**Date Inspected:** 17-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Shen Fu Yoo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Trial Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S. Manjunath. Math. was present during the time noted above for observations relative to the work being performed.

This QA Inspector randomly observed the following work in progress:

SEGMENT ASSEMBLY # BAY 19

Welding In progress -Process FCAW:

Welding of weld joint -002 located on PCMK BP025-007. Welder is identified as 062737. ZPMC (QC) CWI is identified as Lu Li Qing. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-B-U2-F.

Welding In progress – Process SAW:

Welding of weld joint -002 located on PCMK BP025-007. Welder is identified as 062816. ZPMC (QC) CWI is identified as Mr. Lu Li Qing. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-L2C-S-2. Noticed the whole plate assembly is turned upside down and back gouging in progress. Back gouging for PCMK BP025-008 Joint No.002 in progress.

Heat Rectification/Straightening

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Noticed Heat Rectification for flatness in progress for weld joint -001 and 003 located on PCMK BP025-008 and Weld Joint -001 and 003 located on PCMK BP025-007. ZPMC QC is identified as Mr. Sheng Jiangao. The heat straightness records recorded by QC appeared to comply with the Record No. HSR1(B)-5854 Rev-0.

Grinding and Welding Rectification

Noticed Grinding and Welding for Visual imperfection during inspection as marked by ZPMC CWI being rectified for Bike Path No. BK 4A-004 and BK 4A-007. Grinding work in progress for BP-26-006 for Transverse stiffeners from Joint No.004 to 023 for fillet weld and 44 to 53 for CJP welds and for BP-26-008 for Transverse stiffeners from Joint No.004 to 023 for fillet weld and 44 to 53 for CJP welds.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

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| Inspected By: | Math,Manjunath | Quality Assurance Inspector |
| Reviewed By: | Miller,Mark | QA Reviewer |
